

- 6 -

Patent Claims

1. A method for producing a heat exchanger box (1) from plastic by means of injection molding,
5 characterized in that an agent is added or a method is used which in each case accelerates the crystallization of the plastic.
2. The method as claimed in claim 1, characterized in
10 that a crystallization accelerator is added to the plastic.
3. The method as claimed in claim 1 or 2, characterized in that an exothermic or endothermic
15 chemical foaming method or a physical foaming method is used.
4. The method as claimed in claim 3, characterized in that pressurized CO₂ and/or N₂ is supplied as physical
20 blowing agent or CO₂ is generated as chemical blowing agent.
5. The method as claimed in claim 3, characterized in that polyethylene-enrobed granules are admixed as
25 chemical blowing agent with the plastic prior to injection molding.
6. The method as claimed in one of the preceding claims, characterized in that the relaxation is
30 accelerated.
7. The method as claimed in one of the preceding claims, characterized in that the plastic is polyamide,
polyphenylene sulfide or polypropylene.
35
8. The method as claimed in one of the preceding claims, characterized in that the plastic is reinforced

- 7 -

with glass fibers.

9. The method as claimed in one of the preceding claims, characterized in that the heat exchanger box 5 (1) is removed from the injection mold at a surface temperature of over 80°C.

10. The method as claimed in one of the preceding claims, characterized in that the heat exchanger box 10 (1) is removed from the injection mold at a surface temperature of 120° ± 10°C.

11. The method as claimed in one of the preceding claims, characterized in that an auxiliary tensioning 15 means (2) is inserted immediately after the heat exchanger box (1) has been removed from the injection mold.

12. A heat exchanger box (1) made from plastic, 20 characterized in that the heat exchanger box (1) is produced using the method as claimed in one of claims 1 to 11.